

# Work Order ID 99492

**\*99492\***

Page 1

April 10, 2013 11:26:30 AM

Item ID: D3255

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Gasket

Start Date: 4/10/13

Start Qty: 54.00

**\*54\***

Cust Item ID:

Required Date: 4/15/13

Req'd Qty: 54.00

**\*54\***

Customer:

Reference:

Approvals:

Process Plan:

*CX*

Date: 13/04/10

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID  
Work Order ID

Operation  
Description

Set Up  
Run Hours

Lot

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Imp.  
Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

100

0.00

**\*100\***

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O:

*19543*

Possible Supplier: Mc Master Carr P/N: 8612K61

Material: Silicone coated fiberglass cloth per AMS 3320F

P/N: SIL/F

36' x 36' x 1/16"

Certificat of conformaty required

*CX 13/04/10 54*

110

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

*54x 13-4-11 SP*

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\*99492\*

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Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: MAT052 0.00

\*130\*

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release 0.00

\*140\*

QC

Memo

0.00

Quality Control

21  
B 4/11

54

54

JMB 4/11

13/4/15

RB-04-12

# Picklist Print

April 10, 2013 11:26:30 AM

Page 1

Work Order ID: 99492

Parent Item: D3255

Parent Item Name: Gasket

Start Date: 4/10/13

Required Date: 4/15/13

Start Qty: 54.00

Required Qty: 54.00

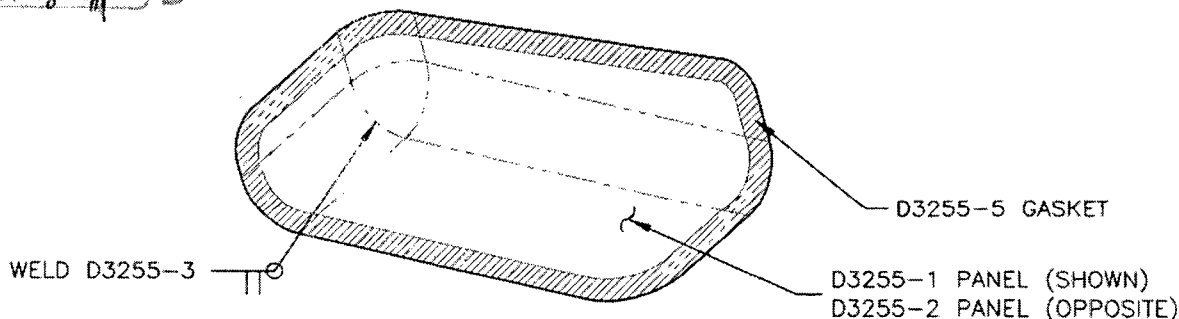
Comments: IPP A04.04.06New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SIL/F36X36X1/16 Gasket		Purchased	No			100	sf	0.0000	1	54	54x	SP 13-4-11	

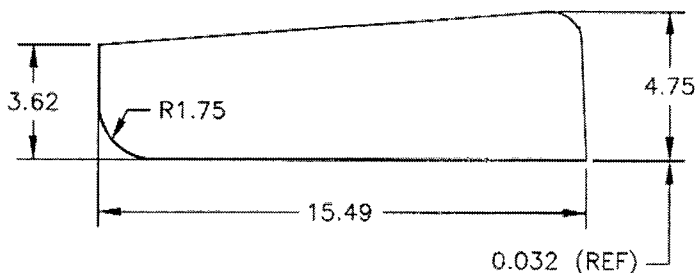
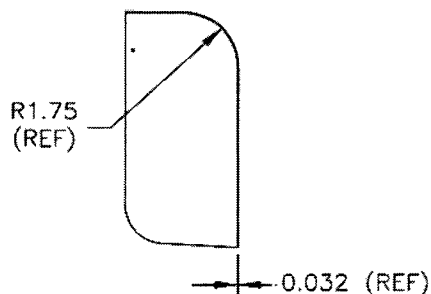
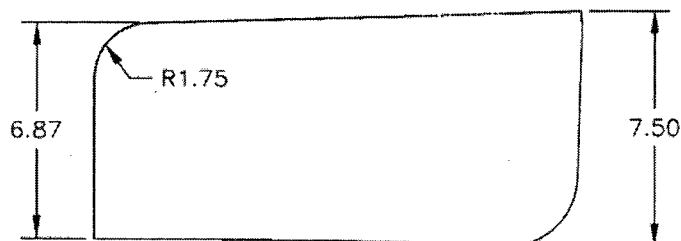


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DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED  
05-01-18 *[Signature]*



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



*CL13/04/10*  
*W10:99492*

**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

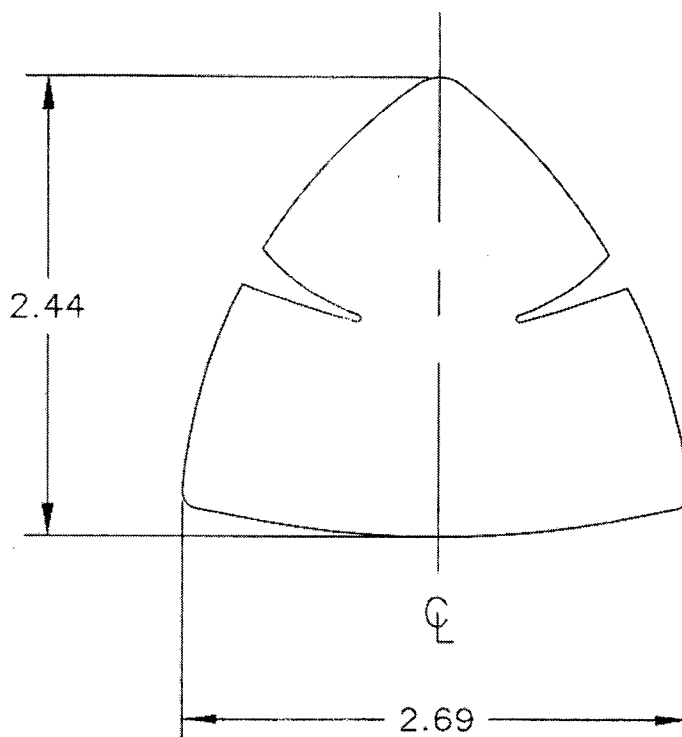
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DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05.01.18 [Signature]



**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

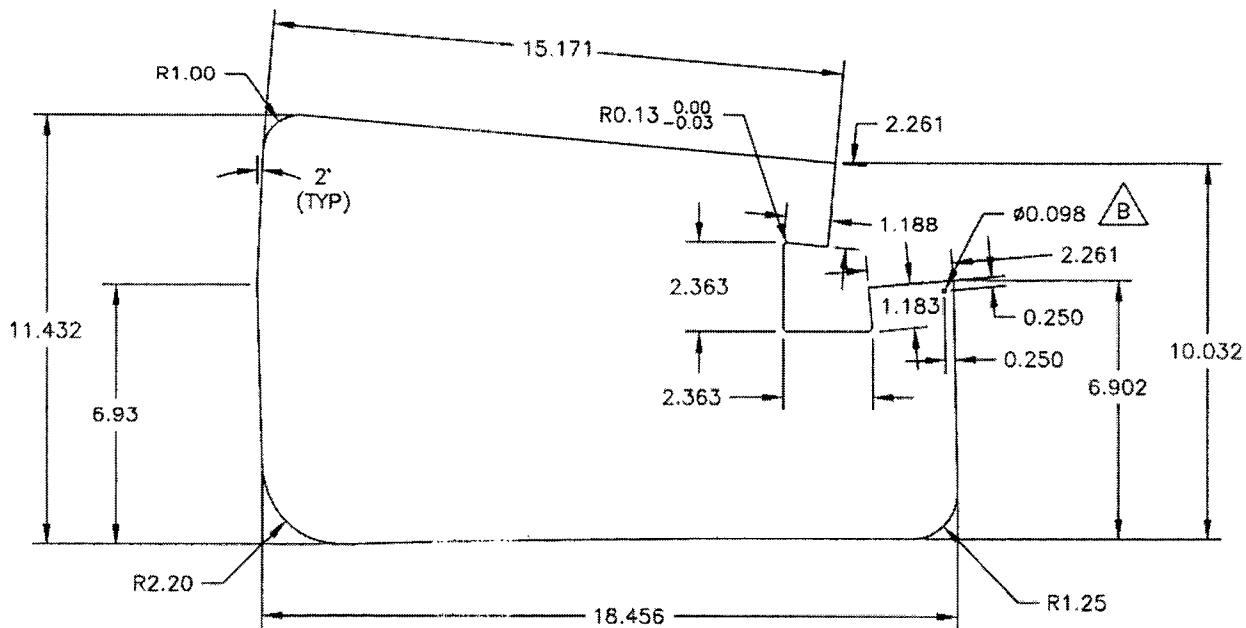
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DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18



### D3255-1/-2 FLAT PATTERN

#### D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

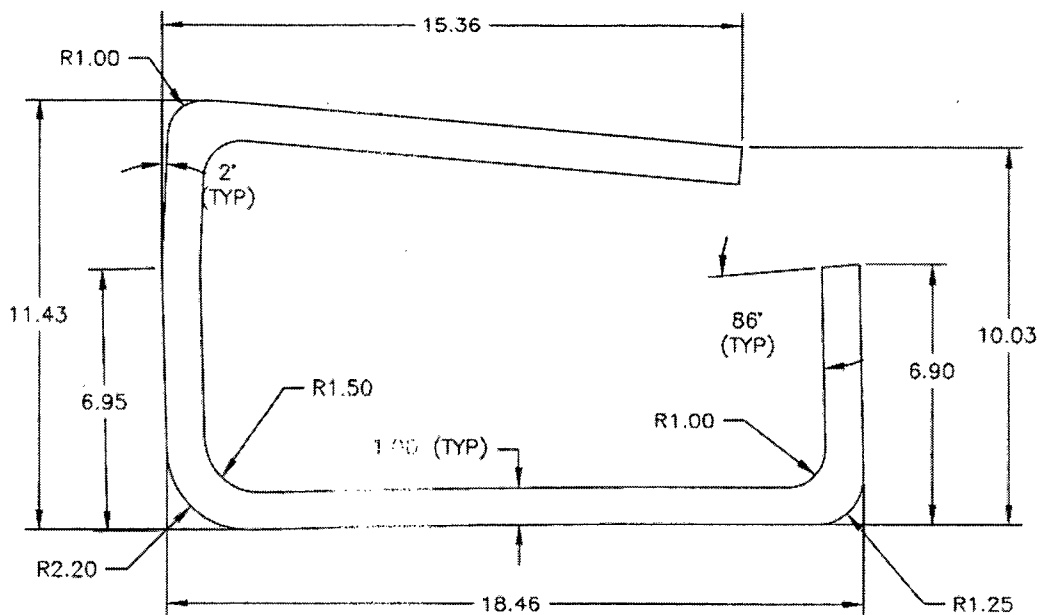
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DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05 01 18 #



### D3255-5 GASKET

#### D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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# McMASTER-CARR®

Purchase Order  
PO19543

Page 1 of 1

200 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

Order Placed By  
Chantal Lavoie

04/10/201

McMaster-Carr Number  
1654605-03

Line	Description	Ordered	Shipped
4	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	9 Each	9
	Unit Price:	\$71.55	
	Extended Price:	\$643.95	

8 - 64 - 37 86 - 73 K61 9 EA  
24 lbs

Shipped separately from our Chicago warehouse on 04/10

2	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long	10 Packs	3
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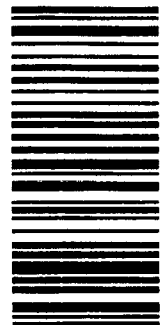
Charges for this shipment

Merchandise Amount	\$643.95
Total:	\$643.95

SP 13411

Dart Aerospace Ltd

EXI  
INV



Lg

38x12x12

FW1F  
04/10  
14:32  
522  
Cycle 1

1140711045526